

Rush



Work Order ID 64747

Page 1

Wednesday, December 15, 2010 1:26:42 PM

Item ID: D3564-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 12/15/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 12/17/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: 11Date: 12-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

100

0.00



FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ***** (D3564-1F) ***** ☐ Dwg Rev: D ☐ Prog
Rev: D ☐ 2-Deburr if necessaryB10-12-15

110

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

B10-12-15

120

0.00



QC8- Inspect parts - second check

0.00

QC

Memo

Quality Control

8/10/12/16

Wednesday, December 15, 2010 1:26:42 PM

Accept

[illegible]**Setup Start**[illegible]

Stop

████████████████████
████████████████████
████████████████████
████████████████████
████████████████████

Cust Item ID:

Start Date: 12/15/2010 **Start Qty:** 12.00

Required Date: 12/17/2010 **Req'd Qty:** 12.00**Customer:**

Reference:

Run Start



Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

NC BRAKE

0.00

Brake NC

Memo

Deburr if necessary □ Form on Brake as per Dwg D3564 using Jigs DT 8179 and DT 8155 □ Form Joggles (2) as per Dwg D3564 on brake using Jig DT 8157

Brake NC

0.00



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

Ensure joggle as per dwg D3429

0.00

[illegible]

Large Fab

0.00

Large Fab

Memo

Large Fab

Qty	Description	Batch	A/R	
1116399	Weld hardcoat as per Dwg D3437			2059B Hardcoat

Work Order ID 64747

Wednesday, December 15, 2010 1:26:42 PM



Page 3

Item ID: D3564-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 12/15/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 12/17/2010 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

1:55

OVEN TEMPERATURE:

320° FINISH TIME:

2:25.



14 10-12-21

Work Order ID 64747

Wednesday, December 15, 2010 1:26:42 PM

Page 4

Item ID: D3564-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearshoe

Start Date: 12/15/2010 Start Qty: 12.00

Cust Item ID:

Required Date: 12/17/2010 Req'd Qty: 12.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10/18/11 SP (140)

200

Identify as per dwg & Stock Location: FP-19 0.00

Packaging

Memo

0.00

Packaging

14. 10-12-21.

210

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

OK 10/12/22

10/12/22
(12)

Picklist Print

Page 1

Wednesday, December 15, 2010 1:26:46 PM

Work Order ID: 64747



Parent Item: D3564-1



Parent Item Name: Wearshoe


Start Date: 12/15/2010

Required Date: 12/17/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA  304/316 Sheet .063		Purchased	No			100	sf	113.0000	1.41	17.81053			
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						MAT	113						
						111323	0						
						115953	113						



1810-12-15

(14)

115953

W/O: ,		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 64747
Description: Wearshoe		Part Number: D3564-1
Inspection Dwg: D3564	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

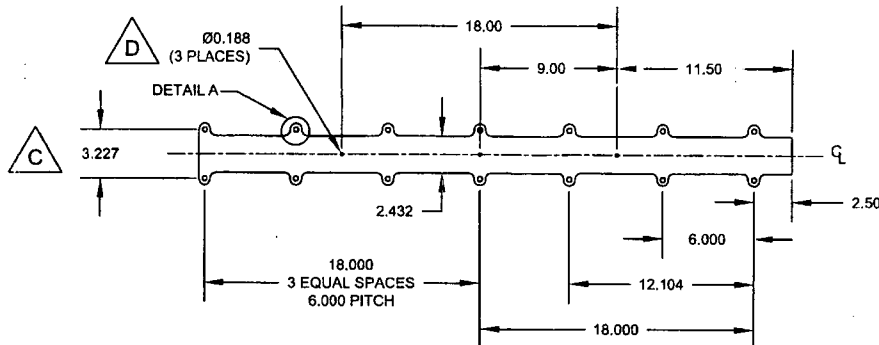
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.224	✓		V 1802	
2.432	+/-0.010	2.438	✓		V	
2.50	+/-0.030	2.50	✓		V	
6.000	+/-0.010	6.002	✓		T 1801	
12.10	+/-0.010	12.10	✓		T	
18.000	+/-0.010	18.000	✓		T	
18.00	+/-0.030	18.00	✓		T	
9.00	+/-0.030	9.00	✓		T	
11.50	+/-0.030	11.50	✓		T	
0.300 x 0.300	+/-0.010	301 x 303	✓		V	
Ø0.188	+0.005/-0.001	.187	✓		V	
R0.375	+/-0.010	.375	✓		R.G.	
0.063	+/-0.010	.057	✓		V	

Measured by: B	Audited by: J	Prototype Approval: N/A
Date: 10-12-15	Date: 10/12/16	Date: N/A

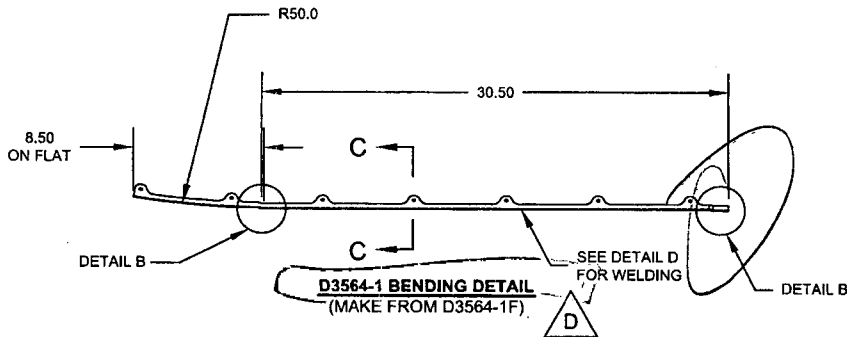
Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	09.05.07	Dwg Rev updated	KJ/EC	

8 7 6 5 4 3 2 1

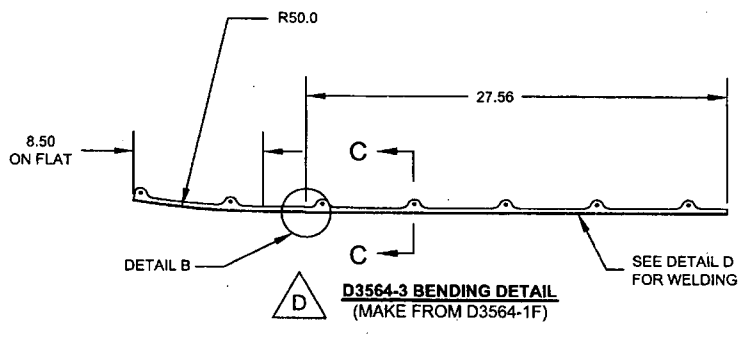
UNCONTROLLED
SUBJECT TO APPROVAL
WORK ORDER
NO. 64747



D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:

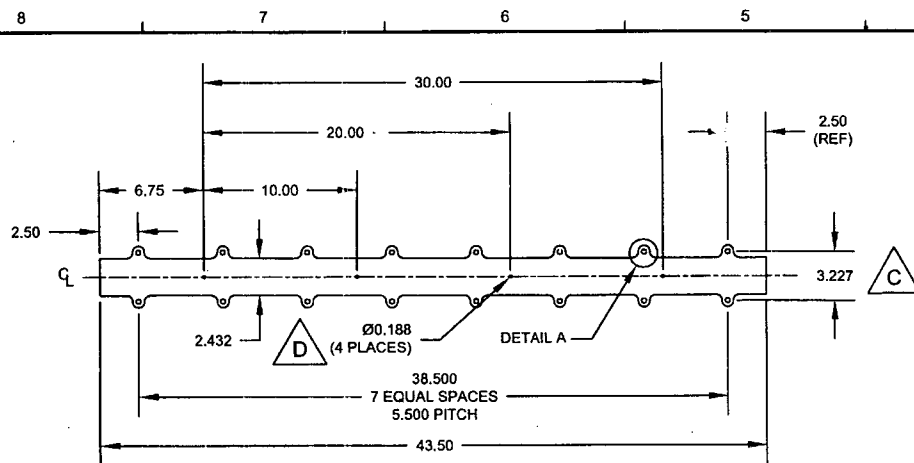
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		

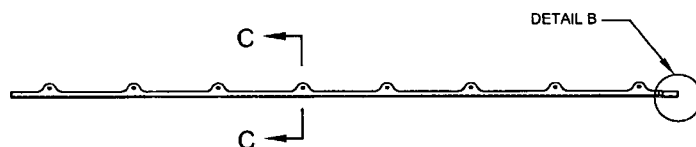
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3564
REV. D
SHEET 1 OF 3
TITLE WEARSHOE
SCALE 1:8

COPYRIGHT © 2006 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

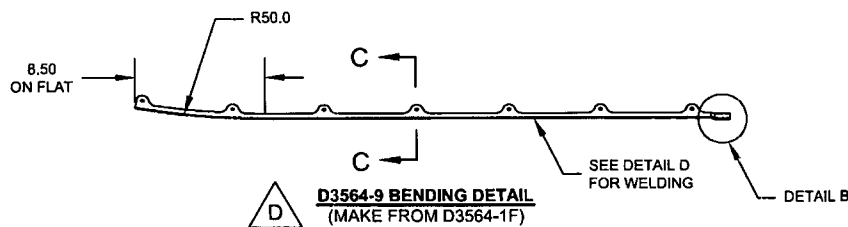


D3564-5F FLAT PATTERN

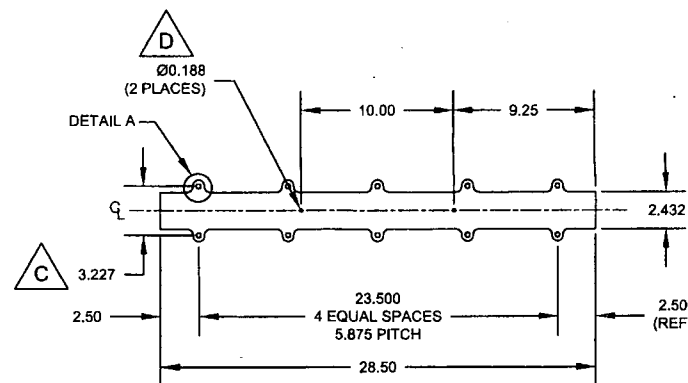


D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)

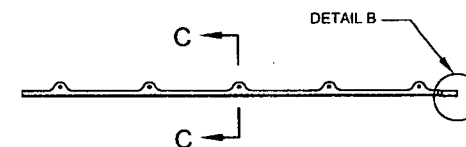
w/064747



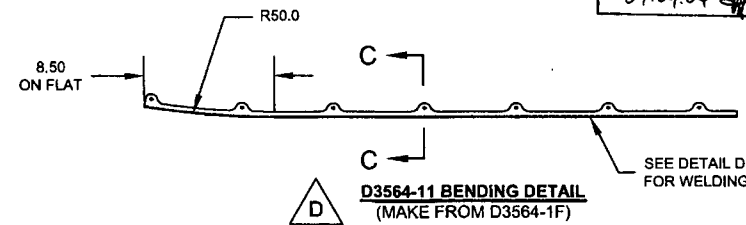
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



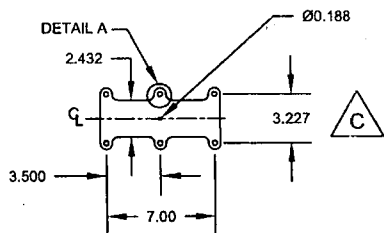
D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED

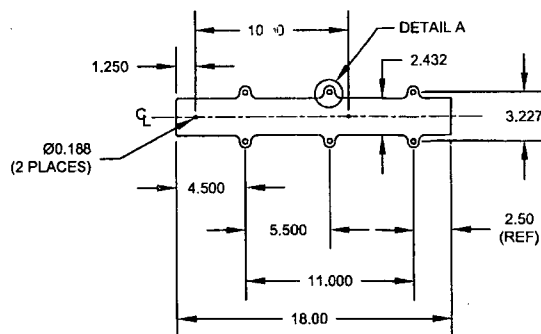
07.09.04

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

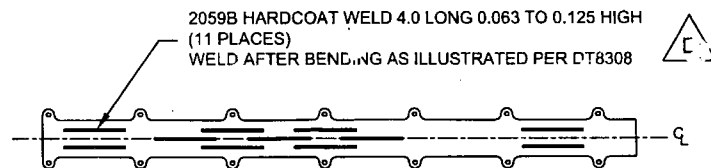
8 7 6 5 4 3 2 1



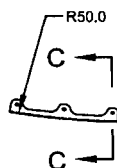
D3564-13F FLAT PATTERN



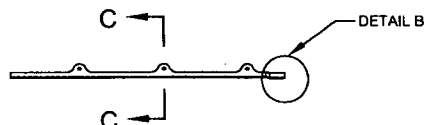
D3564-15F FLAT PATTERN



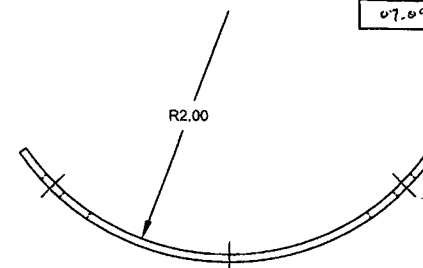
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



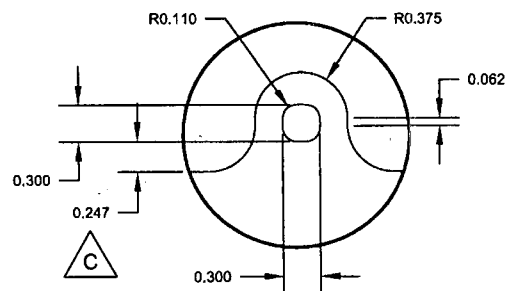
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



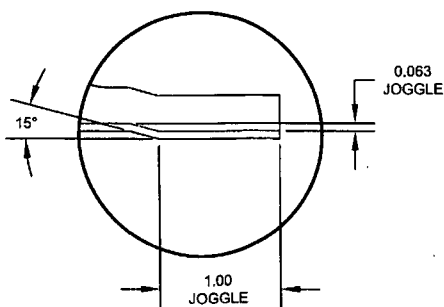
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

RELEASED

07.09.04

W064747

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1